

Date: Wednesday, 15/10/2008 4:37:11 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TURNING DETAIL FOR D2940-1
Job Number	: 42613		
Estimate Number	: 13237		
P.O. Number	:	Part Number	: DSK081
This Issue	: 15/10/2008 S.O. No. :	Drawing Number	: DSK081 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 42375	Material	:
Written By	:	Due Date	: 24/10/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUD 08.10.15</u>		
Comment	: est rev A. 08.03.13 new issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6104007	Round Billet, 17-4
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

BATCH: B41967J.F. 08/10/29

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE  
 Turn blank as per Folio FA079

J.F. / SD 08/11/01

3.0	*QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / SD 08/11/01

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 08/11/02 (10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Identify and Stock in Kanban  
 Location: CNC

J.F. 08/11/02 (10)

6.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/11/03

Job Completion

U 08.11.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42613
<b>Description:</b> Turning Detail for D2940-1		<b>Part Number:</b> DSK081
<b>Inspection Dwg:</b> DSK081	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216		3.211	3.212	3.212	3.211	3.212
B	4.946	4.966		4.956	4.956	4.956	4.956	4.956
C	0.718	0.738		.730	.730	.730	.730	.730
D	0.090	0.110		.101	.102	.101	.101	.101
E	3.564	3.584		3.575	3.575	3.575	3.575	3.575
F	0.022	0.042		.031	.031	.031	.031	.031
G	3.444	3.464		3.455	3.455	3.455	3.455	3.455
H	0.112	0.132		.121	.121	.121	.121	.121
I	2.170	2.190		2.180	2.180	2.180	2.180	2.180
J	4.451	4.471		4.461	4.461	4.461	4.461	4.461
K	0.413	0.433		.424	.424	.424	.424	.424
L	0.913	0.933		.925	.925	.925	.925	.925
M								
N								
O								
P								

Measured by: <i>JA</i>	Date: 08/11/01
Audited by: <i>[Signature]</i>	Date: 08/11/01
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 42013
Description: Turning Detail for D2940-1		Part Number: DSK081
Inspection Dwg: DSK081	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

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Lathe Section								
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D	0.090	0.110		.101	.101	.101	.101	.101
E	3.564	3.584		3.574	3.574	3.574	3.574	3.574
F	0.022	0.042		.031	.031	.031	.031	.031
G	3.444	3.464		3.454	3.454	3.456	3.454	3.454
H	0.112	0.132		.123	.123	.123	.123	.123
I	2.170	2.190		2.181	2.181	2.181	2.181	2.181
J	4.451	4.471		4.461	4.461	4.461	4.461	4.461
K	0.413	0.433		.424	.424	.424	.424	.424
L	0.913	0.933		.925	.925	.925	.925	.925
M								
N								
O								
P								

Measured by: SA Date: 08/11/01

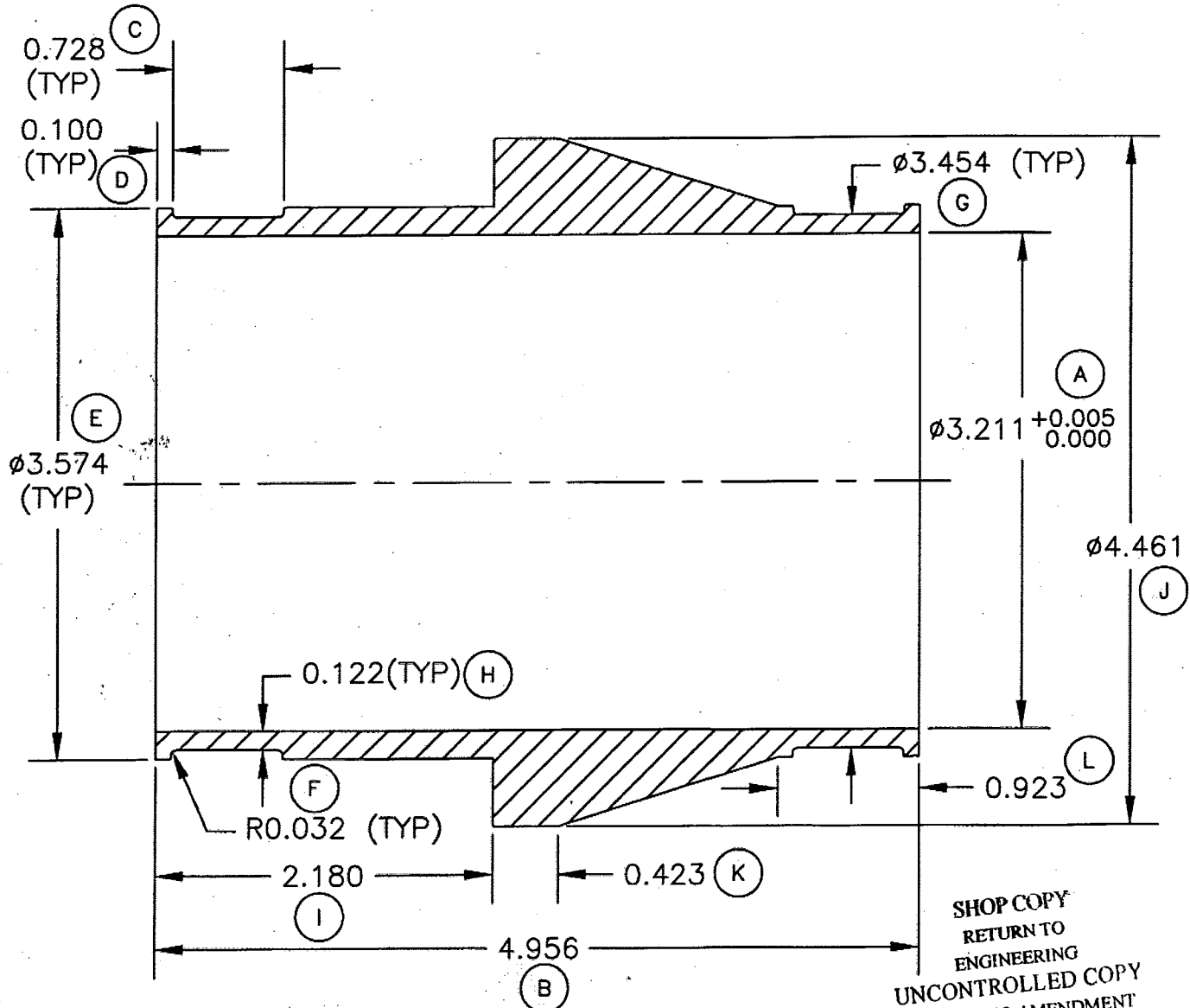
Audited by: SB Date: 08/11/01

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

**DART**

DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

**RELEASED**  
03.07.01 [Signature]**D2940-1 TURNING DETAIL**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 42613

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